

Work Order ID 123235

August-01-14 8:09:11 AM

\*123235\*

Page 1

Item ID: D4074-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Bracket

Stop \*NS2\*

Start Date: 8/01/14 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 8/08/14 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals: Process Plan: U Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4074	C								
100		0.00							
*100*									
Waterjet									
FLOW CNC Waterjet									
	Memo	0.00							
	1-Cut as per Dwg								
	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
*110*									
QC									
Quality Control									
	Memo	0.00							

DAS  
46  
9-89

14/08/01

DAS  
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9-89

14/08/01

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Item ID: D4074-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 8/01/14 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 8/08/14 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 38 9-89 14/08/01				(12)			
130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg  Memo	0.00 0.00				12x		14/08/05	DAS 36 9-89
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 DAS 38 9-89 14/08/06		DAS 16 9-89 14081.6		(12)			

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 8/01/14      **Start Qty:** 12.00      **\*12\***

**Cust Item ID:**

**Required Date:** 8/08/14      **Req'd Qty:** 12.00      **\*12\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop** **\*NR2\***

[illegible]

Chemical Conversion Coat per QSI005 4.1

0.00

**\*1.50\***

## Memo

0.00

HandFinish

## Hand Finishing

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*160\***

128959

0.00

Powdercoat

## Powder Coating

## Memo

POWDER COAT:

Start Time: 135

Oven Temperature: 320

Finish Time: 205

**DAS**

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**9-89**

14-8-11

QC3- Inspect Part Finish

0.00

**\*170\***

## Memo

0.00

QC

## Quality Control

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Item ID: D4074-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 8/01/14 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 8/08/14 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>21086</u>	0.00							
<b>*180*</b>									
Packaging	Memo	0.00				<u>12X</u>	<u>DAS</u>		<u>AUG 12 2014</u>
Packaging							<u>28</u>		
							<u>9-89</u>		
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

ML5 14-08-12  
ML5 14-08-12

# Picklist Print

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Work Order ID: 123235

**\*123235\***

Parent Item: D4074-1

**\*D4074-1\***

Parent Item Name: Bracket

Start Date: 8/01/14

Required Date: 8/08/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A 10.06.08 new issue DD verf:EC

IPP REV:B

AS PER ECN 11-613 11-07-25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased			No			100	sf	132.0730	0.0452	1	

**\*M6061T6S 125\***

6061-T6 .125 Sheet

**\*\***

*c.7*

DAS

**46**

9-89

*17/08/01*

Location

Loc Qty

Loc Code

MAT021

132.073

m127272

29.9

m127454

59.833

m127501

9.6

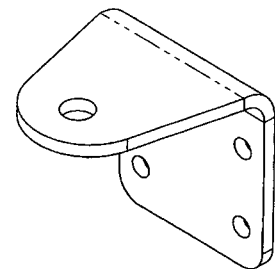
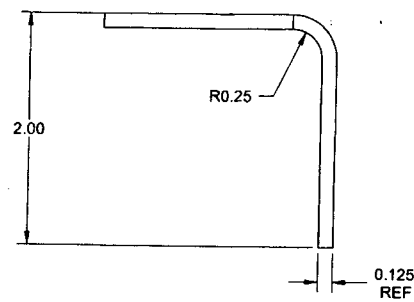
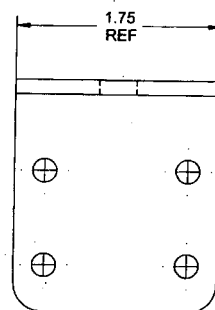
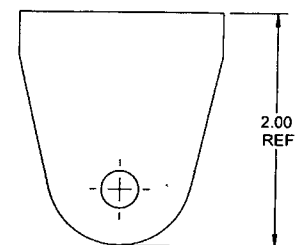
m128852

32.74

*0.7*



also  
123235



**D4074-1 BRACKET**  
(MAKE FROM D4074-1F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: MAKE FROM D4074-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

RELEASED  
2011-10-26

C	MODIFY -7 STRIKER PLATE, SHEET 6 AND 7	HS	11.10.12
B	Ø0.173 WAS Ø0.129 (ZN B3-4); 1.28 WAS 0.80 (ZN C4-6); 1.93 WAS 1.55 (ZN C2-7); 2.10 WAS 1.72 (ZN C1-7)	RF	11.03.07
A	NEW ISSUE	HS	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA DRAWING NO. <b>D4074</b> TITLE <b>BRACKET</b> SCALE <b>NTS</b> REV. C SHEET 1 OF 7 DATE <b>11.10.12</b>	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	11.10.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

D

C

B

A

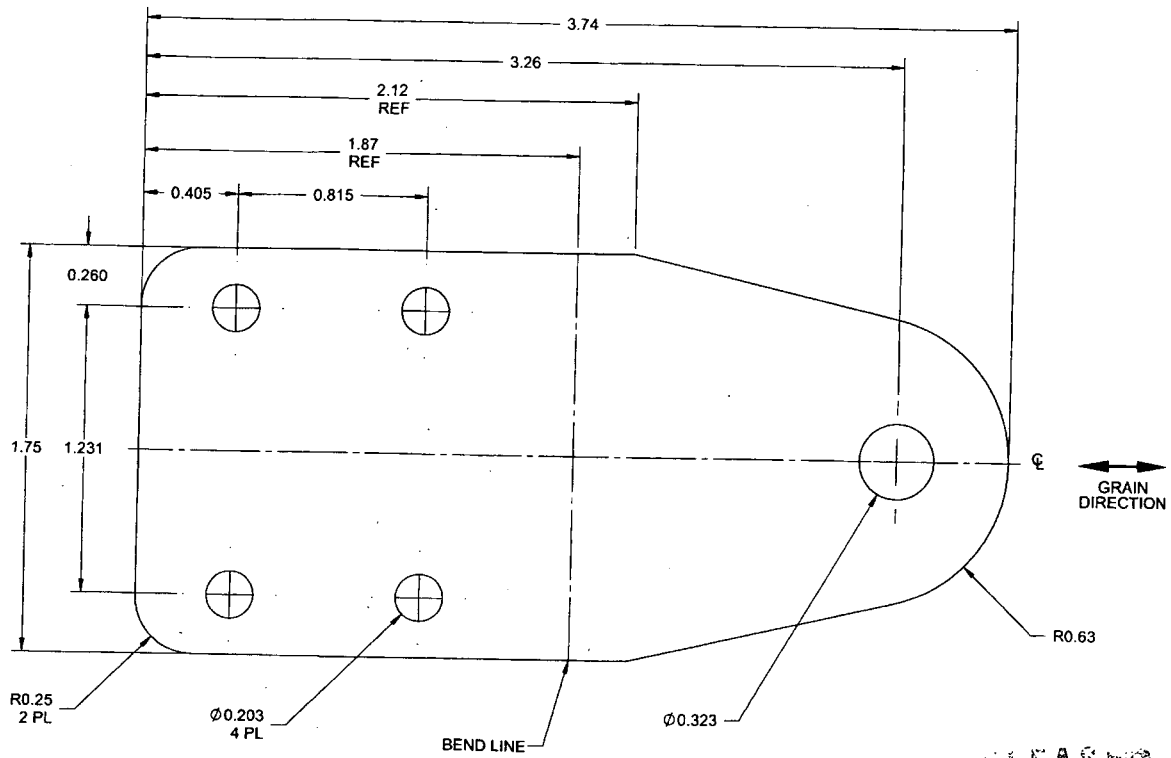
D

C

B

A

0.125  
REF








**D4074-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED  
2011-10-26  
AN

DESIGN		DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED		DRAWING NO. D4074	REV. C
MFG. APPR.			SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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